

Glossy Black

Work Order ID 77296

77296

Page 1

December-01-11 3:24:42 PM

Item ID: D350-636-101GB

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Toe Step, LH/RH

Start Date: 12/01/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/09/11 Req'd Qty: 1.00

1

Customer:

Reference: Rework

Approvals: Process Plan: W
QC:

Date:

Tooling:

Date:

Run Start *NR1*

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3487

Rev A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-636-101 CHG001

5/11/2/08

for MLT 11-12-8
①

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

PULL FROM STOCK:

1 X D350-636-101 B

scuff lightly

71606

1X ✓ M-11/12/08

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

180

Powdercoat

Memo

0.00

Powder Coating

RE-POWDER COAT

GLOSSY BLACK

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

11:00 10:30

320°F

1X ✓ M-11/12/08

M118025

Work Order ID 77296

December-01-11 3:24:42 PM

77296

Page 2

Item ID: D350-636-101GB

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Toe Step, LH/RH

Start Date: 12/01/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/09/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

190

Wing Walk as per dwg QSI005 4.4 Batch 118998 0.00

190

HandFinish

Memo

0.00

Hand Finishing

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

210

Packaging

0.00

210

Packaging

Memo

0.00

Packaging

REPACKAGE PER PPP
USING NEW B/N
Identify and pack for shipping as per PPP D350-636-101
Location: _____
PPP Rev: A

1 DL 11-12-8.

[Handwritten signature]

[Handwritten signature]

Work Order ID 77296

December-01-11 3:24:42 PM

77296

Page 3

Item ID: D350-636-101GB

Revision ID:

Item Name: Toe Step, LH/RH

Start Date: 12/01/11 Start Qty: 1.00

Required Date: 12/09/11 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.00

Quality Control

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Run Start ***NR1***Stop ***NR2***

11/12/11
MF
11-12-09

Picklist Print

December-01-11 3:24:42 PM

Page 1

Work Order ID: 77296

Parent Item: D350-636-101GB

Start Date: 12/01/11

Required Date: 12/09/11

Parent Item Name: Toe Step, LH/RH

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-03-03 JLM
house DD verf:JLM

IPP Rev:B 11.03.15 now made in

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-636-101 Toe Step, LH/RH		Manufactured	No				Each	10.0000		1			

Location

Loc Qty

Loc Code

FG120

10

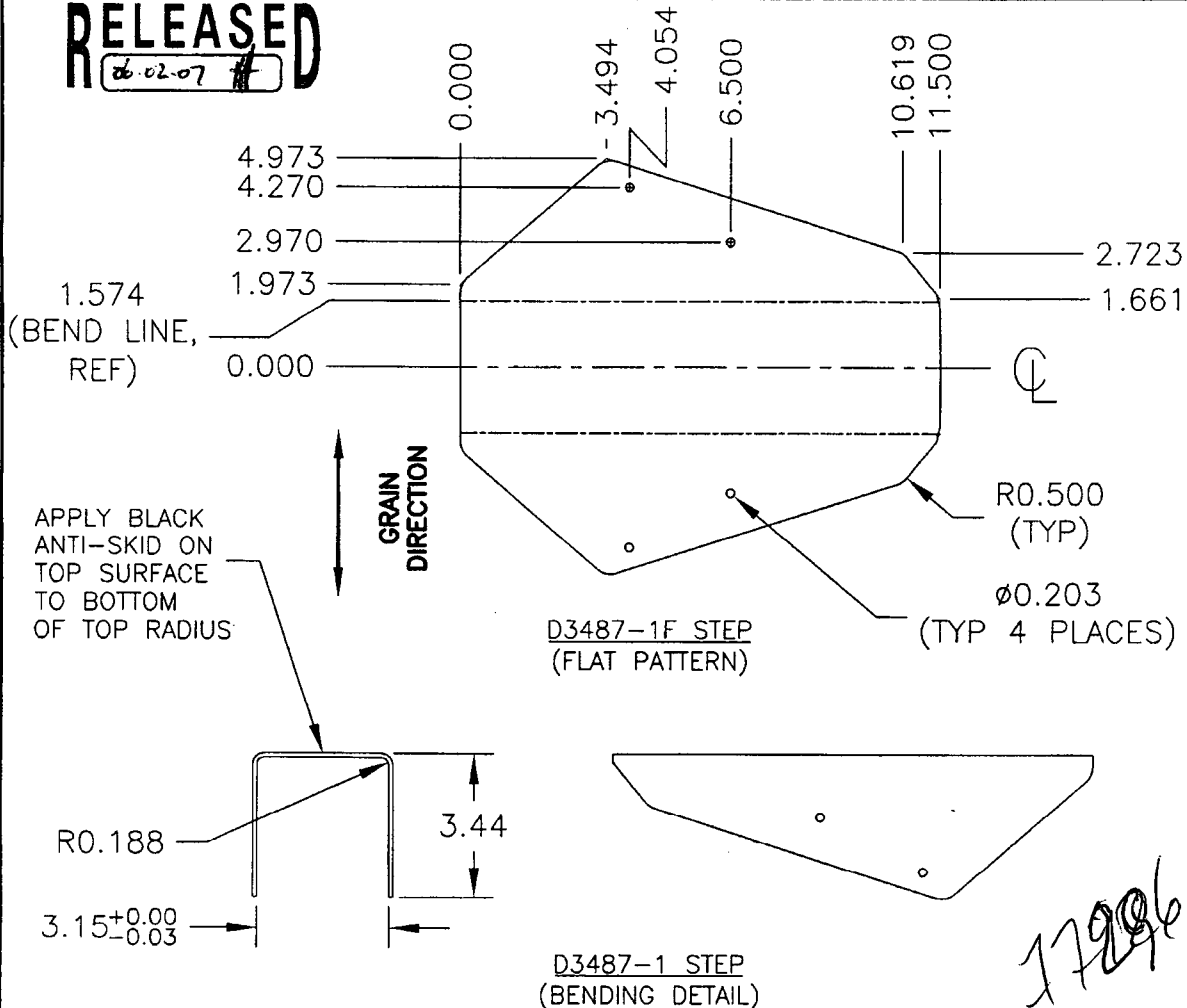
71606

10

~~1X~~ m-f 11/12/08

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3487	REV. A SHEET 1 OF 1
DATE 06.01.16	TITLE STEP		SCALE 1:4
A	06.01.16	NEW ISSUE	

RELEASED
06.02.07 *#***D3487-1 STEP**

- 1) MATERIAL: ALUMINUM 6061-T6/T651 ALUMINUM (QQ-A-250/11) 0.100 THICK (REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) BREAK UNMARKED EDGES 0.005 TO 0.010 MAX

Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

7.0 PARTS LIST

(D350-636-101/-103/-104/-105A/-105B/-107/-107A/-107B/-109 KITS)

Item	Qty -101	Qty -103	Qty -104	Qty -105A	Qty -105B	Qty -107	Qty -107A	Qty -107B	Qty -109	Part Number	Description
	X									D350-636-101	TOE STEP KIT (LH/RH)
		X								D350-636-103	APICAL FLOAT CONVERSION KIT, LH
			X							D350-636-104	APICAL FLOAT CONVERSION KIT, RH
				X						D350-636-105A	WEDGE KIT
					X					D350-636-105B	WEDGE KIT
						X				D350-636-107	CABLE GUARD KIT
						1	X			D350-636-107A	FWD CABLE GUARD
						1		X		D350-636-107B	AFT CABLE GUARD
									X	D350-636-109	TOW RING KIT
8		1								D3488-041	BLADE FITTING, LH (REPLACES D2742-1)
8			1							D3488-042	BLADE FITTING, RH (REPLACES D2742-2)
10		2	2							AN8C21A	BOLT (REPLACES AN8-16A)
11		2	2							AN960JD816	WASHER (OR NAS1149D0863J)
12		2	2							MS21083C8	NUT (REPLACES MS21083N8)
26B		4	4							AN3C7A	BOLT (REPLACES AN3-7A)
27		4	4							AN960C10L	WASHER (REPLACES AN960JD10)
40	1									D3487-1	TOE STEP ASSEMBLY
43		2	2							D3493-1	WASHER
50		2	2							D3532-1	WASHER
60				2						D3926-1	WEDGE
61					2					D3926-3	WEDGE
62				4	4					MS21042L3	NUT
63				4	4					MS24693S276	SCREW
64				4	4					NAS1149D0363J	WASHER
70							1			D3927-1	FWD CABLE GUARD
71								1		D3927-3	AFT CABLE GUARD
72							2			D3928-1	BRACKET
73							2			AN4-14A	BOLT
74								1		BLBS-020	PIP PIN
75							2			MS21042L4	NUT
76							4			NAS1149D0463J	WASHER
80									1	D3407-043	TOW RING ASSEMBLY
81									2	D3417-9	WASHER
82									1	D3456-1	WASHER
83									1	MS21043-4	NUT